

54426 DRW

Work Order ID 53908



November 23, 2009 2:41:15 PM

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 23/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *BP*

Date: *09-11-23*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

8 62/12/08

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

CK

MB 09-11-30

B53908

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

i - AW 09-12-03

① BE 09-12-03

W/O:		WORK ORDER CHANGES					
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November 23, 2009 2:41:15 PM



Page 3

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

M112507

BE 09/2/03

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

M112507

BE 09/2/03

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Towing using DT8091, open to .640" and Debur

BE 09/2/07

W/O:		WORK ORDER CHANGES					
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Page 4

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	⇒ 809/12/07			<u>H</u>			
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	⇒ 809/12/07			<u>(H)</u>	<u>φ</u>		
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00	⇒ 809/12/07			<u>(H)</u>	<u>φ</u>		

W/O:		WORK ORDER CHANGES					
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Page 5

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M112148.

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:45
320°
2:15

0.00

SL 09-12-7

①,

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

=> M109112100

0.00

Memo

ⓧ①

Ø

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November 23, 2009 2:41:15 PM



Page 6

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200

0.00



HandFinish

Memo

0.00

=> Hl 09/12/08

(X1)

0

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M112345
Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M112345
Sikaflex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: M112623

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November 23, 2009 2:41:15 PM



Page 7

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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210

QC5- Inspect part completeness to step on W/O

0.00



27 809/12/08

QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

④

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: I

809/12/08

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/10

RL 0912-9

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Picklist Print

November 23, 2009 2:41:21 PM

Page 1

Work Order ID: 53908

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube



Comments:

Start Date: 23/11/2009

Required Date: 02/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD  205 Skidtube bent detail		Manufactured	No			110	Each	1.0000	1.0000			
				<u>Warehouse</u>				<u>Loc Qty</u>	<u>Loc Code</u>			
				<u>Location</u>								
				Main Warehouse								
				ST				1				
					53233			1				
D2576-3RevG  Step (maching detail)		Manufactured	No			140	Each	160.0000	1.0000			
				<u>Warehouse</u>				<u>Loc Qty</u>	<u>Loc Code</u>			
				<u>Location</u>								
				Main Warehouse								
				ST				160				
					43504			12				
					46661			101				
					52215			47				

6-53539 MS 09-11-30

1 BE 09/12/03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

November 23, 2009 2:41:21 PM

Work Order ID: 53908

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 23/11/2009

Required Date: 02/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2579RevE		Manufactured	No			140	Each	193.0000	20.0000			
-----------	--	--------------	----	--	--	-----	------	----------	---------	--	--	--



Crossbolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

71

51525

71

Main Warehouse

ST

122

43988

4

46434

4

46956

2

47797

9

48272

2

51314

71

51315

30

D2855RevA

Manufactured No



Cap

200 Each 92.0000 1.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP6

92

50513

1

50770

3

51539

88

XI 09/12/08

November 23, 2009 2:41:21 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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November 23, 2009 2:41:21 PM

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Comments:

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3-5A		Purchased	No			200	Each	2,171.000	2.0000			
Bolt												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2171	
100188	188	
(105057)	1983	

x2 21 09/12/08

AN960JD10L		Purchased	No			200	Each	5,592.000	2.0000			
Washer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5592	
101291	16	
104885	153	
105793	236	
(109632)	348	
110985	4839	

x2 21 09/12/08

Dart Aerospace Ltd

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Page 4

November 23, 2009 2:41:21 PM

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			200	Each	2,880.000	50.0000			

Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2880	
105855	16	
108606	52	
111529	1488	
111779	313	
112772	11	
113238	1000	

x50 43 09/12/09

AN3C4A

Purchased

No

200

Each

2,075.000

50.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2075	
112314	13	
112720	12	
112724	3	
112829	88	
112991	39	
113121	920	
113226	1000	

M113359

x50 44 09/12/09

W/O:		WORK ORDER CHANGES					
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AN960C10L  washer		Purchased	No			200	Each	2,604.000	50.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>	X	
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	2504	
112116	548	
112612	956	
<u>112933</u>	1000	

D3566-13RevC

Manufactured No



Gasket

200 Each 106.0000 1.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	104	
<u>51606</u>	21	
53461	83	
Main Warehouse		
ST	2	
45717	1	
50265	1	

X 50 11 09/12/08

X 1 11 09/12/08

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Page 6

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D3566-5RevC		Manufactured	No			200	Each	48.0000	1.0000			
Gasket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	28	
51929	2	
53804	26	
Main Warehouse		
FP19	16	
52909	16	
Main Warehouse		
ST	4	
36113	1	
46186	1	
47318	1	
51260	1	

x1 11/01/2009

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D3566-1RevC		Manufactured	No			200	Each	65.0000	2.0000			
Gasket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	36	
52512	3	
53790	33	
Main Warehouse		
ST	29	
46349	1	
51218	1	
51259	3	
53455	24	

x2 41 09/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 2:41:21 PM

Work Order ID: 53908



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-11RevD		Manufactured	No			200	Each	33.0000	1.0000			
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	5	
51905	5	
Main Warehouse		
FP19	26	
51594	3	
52125	23	
Main Warehouse		
ST	2	
45823	1	
50112	1	

B53803

x1 Hl 09/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 9

November 23, 2009 2:41:21 PM

Work Order ID: 53908



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3564-13RevD Manufactured No 200 Each 46.0000 1.0000



Wearshoe

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP17	34	
51611	32	
52059	2	
Main Warehouse		
ST	12	
45409	2	
46495	10	

x1 28 09/12/08

D3564-9RevD Manufactured No 200 Each 21.0000 1.0000



Wearshoe

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP19	19	
51675	1	
52593	18	
Main Warehouse		
ST	2	
44659	1	
45825	1	

1353806

x1 28 09/12/08

November 23, 2009 2:41:21 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 10

November 23, 2009 2:41:22 PM

Work Order ID: 53908



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3564-5RevD

Manufactured

No

200

Each

24.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

B53805

x1 31 09/12/08

FG

2

34806

2

Main Warehouse

FP19

7

51925

7

Main Warehouse

ST

15

45824

1

47433

1

52595

13

D2594-3RevC

Manufactured

No

200

Each

840.0000

16.0000



O-Ring, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

27

51613

27

Main Warehouse

ST

813

52562

813

X16 31 09/12/08

November 23, 2009 2:41:22 PM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 11

November 23, 2009 2:41:22 PM

Work Order ID: 53908



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-1RevC		Manufactured	No			200	Each	431.0000	16.0000			
Plug, 205 Skidtube												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	431	
42221	16	
42807	92	
43884	3	
46435	2	
51527	9	
51757	309	

x16 M 09/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53908

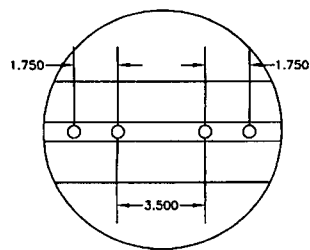
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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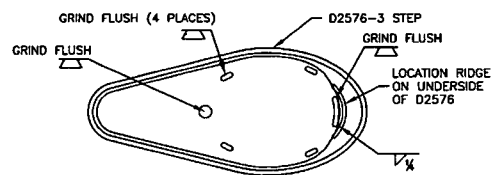
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DETAIL A
SCALE 5:24

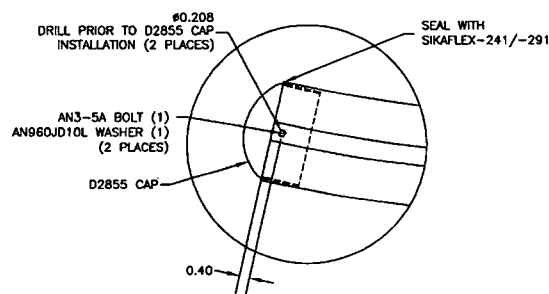


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07-06-28-11

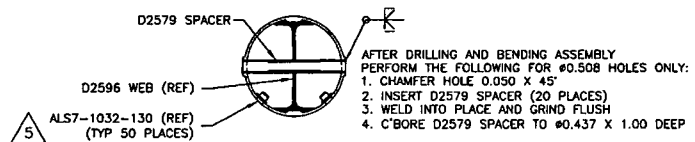
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SCALE 5:24



DETAIL C
SCALE 5:24



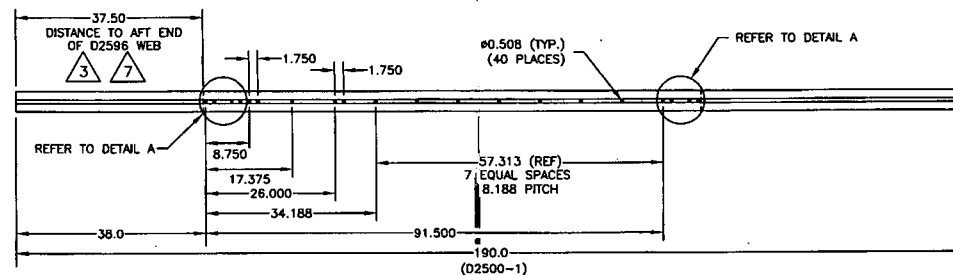
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SCALE 5:24



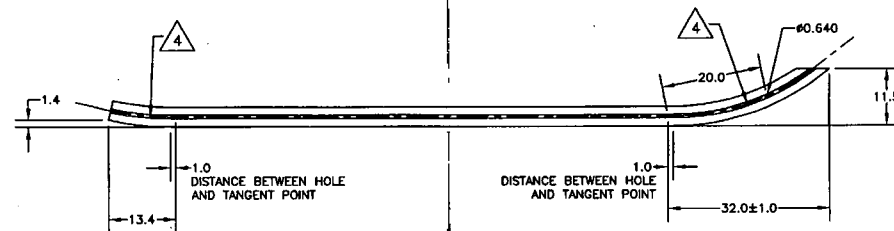
D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

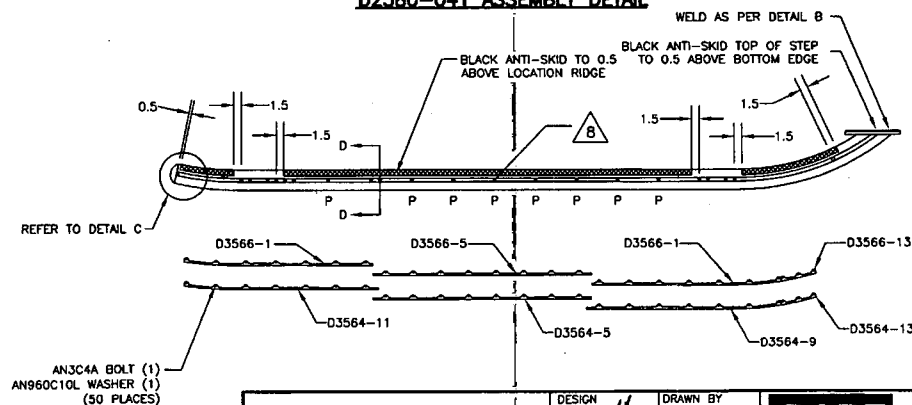
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



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DESIGN	11
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DATE _____

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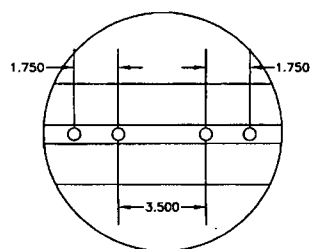
APPROVED

DART DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV. 0
D2580	SHEET 2 OF 3

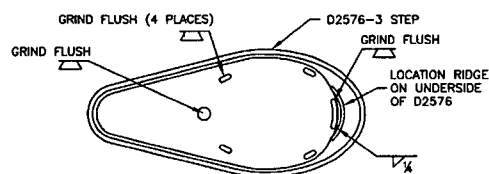
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

DETAIL E
SCALE 5:24

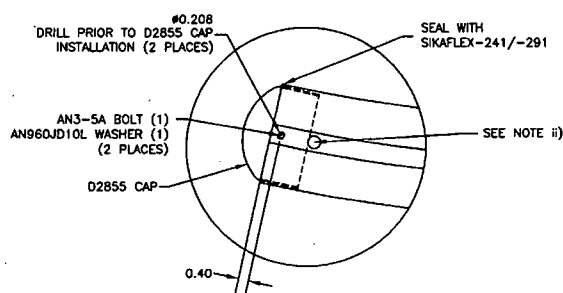


RELEASED
07 Dec 28

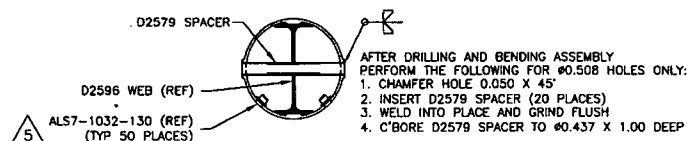
DETAIL F
SCALE 5:24



DETAIL G
SCALE 5:24



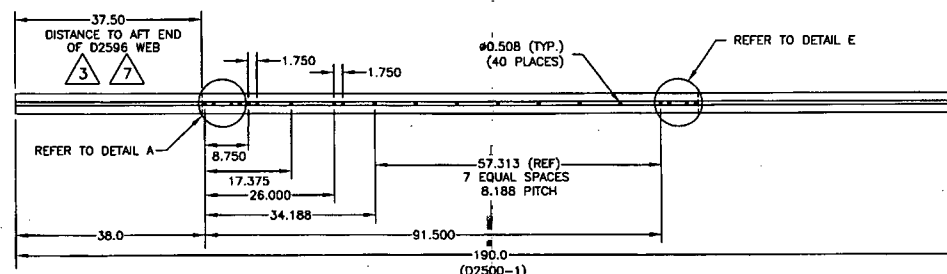
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SCALE 5:24



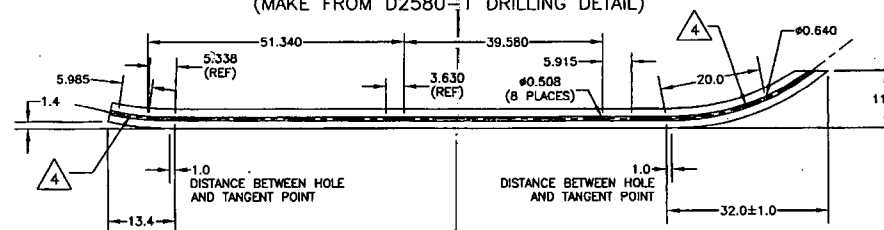
D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

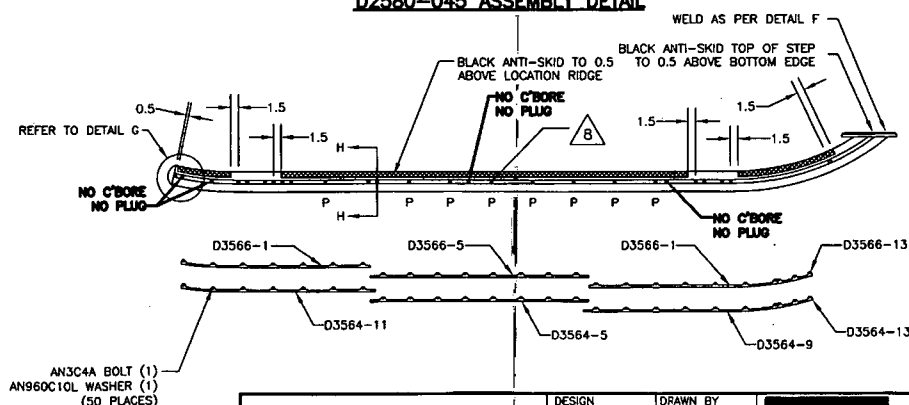
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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DESIGN

PH

CHECKED 

DATE _____

07.02.27

DRAWN BY

PH

APPROVED	<i>[Signature]</i>
----------	--------------------

[illegible]**DART**

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

10-10-10

DRAWING NO.
D2580

55.6

Title

NAME, SURNAME

REV. 0
SHEET 3 OF 3

NO. 219

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 53910
Part number: D205-634-041
Description: 205 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Durl Date of Test Coupon 09.12.04

Welder Barclay Elliott Date of Test Coupon 09.12.04

The above named individual is qualified in accordance with AWS D17.1.2001 to weld